

Work Order ID 73974

Tuesday, September 20, 2011 10:21:56 AM



Page 1

Item ID: D205-633-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step

Start Date: 9/20/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 10/11/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: *11-09-10*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
N/A	Rev N/A

100
 DOCUMENT CONTROL
 DC
 Document Control

0.00

Memo

0.00

Photocopy bluefile & type labels per PPP205-633-011 CHG001

11 10 28 (6)
HA Doc MLC 11-10-27 (6)

110
 Pick Kit

0.00

Packaging

Memo

0.00

Packaging

11/10/27 (6)

120
 QC4- 100% Inspect kits for completeness

0.00

QC

Memo

0.00

Quality Control

11 10 28 (6)

66150

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73974

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Item ID: D205-633-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step

Start Date: 9/20/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 10/11/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D205-633-011 Location: <u>20</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

Handwritten signatures and initials

Handwritten date and initials: 11/11/02

Handwritten initials and date: MK 11-11-01

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 73974

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step



Start Date: 9/20/2011

Required Date: 10/11/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:F02.07.11 Reformat; Removed D3010 BRF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-14A Bolt		Purchased	No			110	Each	211.0000	1	6			
-----------------	--	-----------	----	--	--	-----	------	----------	---	---	--	--	--

Location Loc Qty Loc Code

ST357	11	
118451	11	
ST358	200	
118628	100	
118706	100	

AN4-5A Bolt		Purchased	No			110	Each	186.0000	2	12			
----------------	--	-----------	----	--	--	-----	------	----------	---	----	--	--	--

Location Loc Qty Loc Code

ST355	180	
117508	180	
ST356	6	
116549	6	

AN4-6A Bolt		Purchased	No			110	Each	1,216.0000	2	12			
----------------	--	-----------	----	--	--	-----	------	------------	---	----	--	--	--

Location Loc Qty Loc Code

ST356	1200	
117872	200	
118422	300	
118628	400	
118838	300	
ST358	16	
117514	16	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 73974

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step

Start Date: 9/20/2011

Required Date: 10/11/2011

Start Qty: 6.00

Required Qty: 6.00

AN4-7A
Bolt
x6

Purchased No

110 Each

200.0000

2

12

Location

Loc Qty

Loc Code

ST356

200

117514

200

110 Each

26.0000

1

6

AN5-14A
Bolt
x6

Purchased No

Location

Loc Qty

Loc Code

ST338

26

115374

26

110 Each

52.0000

1

6

AN5-6A
Bolt
x6

Purchased No

Location

Loc Qty

Loc Code

ST337

52

117313

2

117688

50

110 Each

0.0000

15

90

AN960JD416
Washer
x6

NAS1149D0463J

Purchased No

AN960JD516
Washer
x6

NAS1149D0563J

Purchased No

110 Each

0.0000

4

24

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 73974

Parent Item: D205-633-011

Parent-Item Name: Heli-Access-Step

Start Date: 9/20/2011

Required Date: 10/11/2011

Start Qty: 6.00

Required Qty: 6.00

h/w
x6

D2021-101



Eyebolt

Manufactured No

110 Each

22.0000



6

Location

Loc Qty

Loc Code

ST004

22

69527

22

Manufactured No

110 Each


74.0000



6

h/w
x6

D2022-101



Spacer

Location

Loc Qty

Loc Code

ST504

74

69824

14

71840

60

Manufactured No

110 Each


59.0000



12

h/w
x6

D2022-103



Spacer

Location

Loc Qty

Loc Code

ST

40

71862

40

ST005

19

69550

19

Manufactured No

110 Each

1.0000



12

h/w
x6

D2562-001



Strut

Location

Loc Qty

Loc Code

ST264

1

72645

1

Manufactured No

110 Each

0.0000



6

h/w
x6

D2563



Step Weldment Assembly

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Work Order ID: 73974

Parent Item: D205-633-011

Parent Item Name: Heli-Access-Step

Start Date: 9/20/2011

Required Date: 10/11/2011

Start Qty: 6.00

Required Qty: 6.00



Manufactured No

110 Each

4.0000

1 6
B71659 SP

Location

Loc Qty

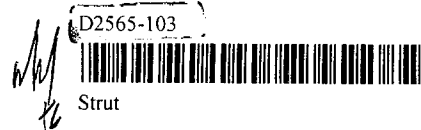
Loc Code

ST270

4

70190

4



Manufactured No

110 Each

2.0000

1 6
B71657 SP

Location

Loc Qty

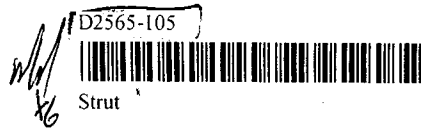
Loc Code

ST270

2

69526

2



Manufactured No

110 Each

3.0000

1 6
B71660 SP

Location

Loc Qty

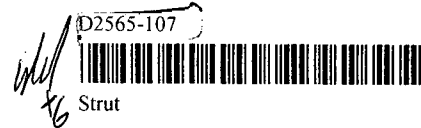
Loc Code

ST270

3

69517

3



Manufactured No

110 Each

1.0000

1 6 5x
B71474 SP

Location

Loc Qty

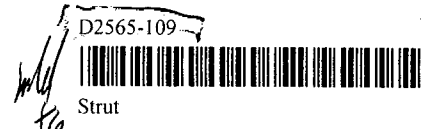
Loc Code

ST270

1

69522

1



Manufactured No

110 Each

5.0000

1 6
B71658 11/10/2011

Location

Loc Qty

Loc Code

ST270

5

64797

1

69524

4

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Parent Item Name: Heli-Access-Step

Start Date: 9/20/2011

Required Date: 10/11/2011

Start Qty: 6.00

Required Qty: 6.00

D2565-111

Manufactured No

110

Each

13.0000

6

Strut

Location

Loc Qty

Loc Code

ST270

13

69523

10

70203

3

Purchased

No

110

Each

4,309.000

8

48

MS21042L4

Nut

Location

Loc Qty

Loc Code

ST300

4309

117441

51

117601

637

117885

621

118451

2000

118927

1000

Purchased

No

110

Each

1,287.000

2

MS21042L5

Nut

Location

Loc Qty

Loc Code

ST300

1287

116105

5

116548

53

117441

343

117611

90

118179

496

118910

300

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

5.0 PARTS LISTS

5.1 D205-633-011/-013/-015/-017 Heli-Access Step

QTY -011	QTY -013	QTY -015	QTY -017	Part Number	Description
X				D205-633-011	Heli-Access-Step™, High Gear
	X			D205-633-013	Heli-Access-Step™, Extended High Gear (31")
		X		D205-633-015	Heli-Access-Step™, Extended High Gear (39")
			X	D205-633-017	Heli-Access-Step™, Standard Low Gear
1			1	D2021-101	EYEBOLT
2	2	2	2	D2022-101	SPACER
2	2	2	2	D2022-103	SPACER
1				D2562-001	STRUT
		1		D2562-005	STRUT
			1	D2562-007	STRUT
	1			D2562-013	STRUT
1	1	1	1	D2563	WELDMENT ASSEMBLY
1				D2565-101	STRUT
1				D2565-103	STRUT
1				D2565-105	STRUT
1				D2565-107	STRUT
1				D2565-109	STRUT
1				D2565-111	STRUT
	1			D2565-201	STRUT
	1			D2565-203	STRUT
	1			D2565-205	STRUT
	1			D2565-207	STRUT
	1			D2565-209	STRUT
	1			D2565-211	STRUT
		1		D2565-301	STRUT
		1		D2565-303	STRUT
		1		D2565-305	STRUT
		1		D2565-307	STRUT
		1		D2565-309	STRUT
			1	D2565-401	STRUT
			1	D2565-403	STRUT
			1	D2565-405	STRUT
			1	D2565-407	STRUT
			1	D2565-409	STRUT
			1	D2565-411	STRUT
		1		D3165-1	SUPPORT ARM
	1	1		AN44-7A	EYEBOLT
2	1	1	2	AN4-5A	BOLT
2	3	3	2	AN4-6A	BOLT
2	2	2	2	AN4-7A	BOLT
1	1	1	1	AN4-14A	BOLT
	1	1		AN4-10A	BOLT
1			1	AN5-6A	BOLT
1	1	1	1	AN5-14A	BOLT
15	16	16	15	AN960JD416	WASHER
4	4	4	4	AN960JD516	WASHER
8	8	8	8	MS21042L4	NUT (or MS21042-4)
2	2	2	2	MS21042L5	NUT (or MS21042-5)

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Revision: B

Date: 07.08.21